

RG 104, 8NS-104-94-077
Box 6

8NS-104-94-077, Miscellaneous
Correspondence & Memos, 1897-1994

Notes on Costa Rican Currency

Notes on Costa Rican Currency

5 - Centimo

Costa Rica

.026
edge - .024
Wt = 15.44
Dia = .591

X-Ray - .043⁺1

Costa Rica

10 - Centimo

.0365 std

Wt = 31 grains

edge .035 = .0355

Dia = 696

25 - CENTIMOS

COSTA RICA

std = .036 = $\pm \frac{1}{2}$ gr.

Wt = 53.24

Dia = .921

NEW-DIA = .921

3 34

2 2

75 Centimo 304

T.T.L 840

25 - CENTIMOS -

COSTA RICA

.037 std.

Wt. 53.24 grains

std
Dia .905 -

COSTA RICA

5-CENTIMO.

Cu-pro-Nix

PASS DIAM GAUGE

1 215 .180

2 180 .145

ANNEAL

3 145 .100

4 115 .076

5 85 .055 X-RAY

6 65 .039 = .060

7 56 .026 = .043⁺

Dim. 591 - edge = .024 - .0245

X-Ray
.039 = .049Costa Rica
25 Centimos

Dia blank .921 (New Dia)

WT. 53.24 grams
app 140 Ingots

Costa Rica
Special Schedule

25 Centimos

Pass	Dial	Gauge
1	5	.215
2	235	.190

anneal

3	180	.145	
4	150	.105	
5	125	.080	
6	100	.060	X ray
7	95	.045	072
8	93	.036	058 ⁺ 1

Also .0355

COSTA RICA - CUPRO-NIX

25-CENTIMO.

PASS	DIAL	GAUGE
1	215	.180
2	180	.145

ANNEAL

3	150	.105
4	125	.080
5	100	.060 X-RAY
6	95	.045 = 072
7	93	.0365 058 ⁺ 1/2

10-CENTIMO.

PASS	DIAL	GAUGE
1	215	.180
2	180	.145

ANNEAL

3	150	.105
4	125	.080
5	100	.060 X-RAY
6	95	.045 = 072
7	93	.0365 = 058 ⁺ 1/2

DIA. 921 - edge .035-.036

.037 = ⁺1/2 gr.

DIA. 696 edge .035-.0355

COSTA RICA

CENTIMOS

5. CENTIMOS 20.000.000 pcs.

.026

.026 Gauge

.546 CUT BLANK

CUPRO NICKEL

.574 UPSET

.591 Finish Coin size

10 - CENTIMOS 10.000.000 pcs.

.035

.035 Gauge

.704 CUT BLANK

CUPRO NICKEL

.696 UPSET ~~Blank~~ ~~Blank~~

.709 Finish Coin size

25 - CENTIMOS - 4.000.000 pcs.
SINGLE STRIKE

.037

~~.037~~ Gauge

CUT BLANK

CUPRO NICKEL

UPSET

905 Finish COIN size - Brazil 10-Centavo die

(B. C. C. R.) Lettering on edge of finished
Coin

.0512 Finish coin

.0512 ? gauge -

Government Costa Rica

No. Pieces 20,000,000

Date order received _____	Was master die furnished <u>No</u>
Mint where coined <u>Denver</u>	Was master die returned <u>No</u>
Denomination <u>5 Centimo</u>	Number melts made <u>260</u> - <u>9</u> scraped <u>251</u>
Date coinage started <u>10-24-69</u>	No, melts delivered to Coiner <u>251</u>
Date coinage completed <u>1-12-70</u>	Ounces per melt <u>5800</u>
Cost per M _____	No. ingots per melt <u>One</u>
Alloy <u>75% Copper 25% Nickel</u>	Weight per ingot <u>400 lbs.</u>
Weight per coin <u>15.432 ⁺ 1 Grain</u>	Size of ingot <u>60" X 12 1/8" X 1 3/4"</u>
Weight tolerance _____	Assay passing tol. on ingot _____
Fineness _____ Tol. _____	Diameter of cut blank <u>591</u>
Diameter <u>.590</u> Tol. <u>⁺ 2</u>	Thickness of cut blank <u>.026</u>
Thickness <u>.035</u> Tol. <u>⁺ 2</u>	Diameter of upset blank <u>.575</u>
Reeded edge <u>Yes</u>	Edge thickness upset blank <u>.045</u>
Plain edge <u>No</u>	Pieces cut across strip <u>15</u>
Lettered edge <u>No</u>	Pieces cut at one stroke <u>18</u>
Wastage allowed per M _____	Annealing temperature <u>1200°</u>
Turn - standard or medal <u>Standard</u>	% rejects, automatic scales _____
Year (dated) <u>1969</u>	% rejects if reviewed _____
Mint mark <u>No</u>	% good coins from ingots <u>50%</u>
Was sample coin submitted <u>Yes</u>	No. pieces per bag <u>20,000</u>
Was sample strike approved <u>Yes</u>	Weight tol., M pieces _____
Date shipped _____	

Remarks:

Obv. Die Average 69,204

Rev. Die Average 60,740

Used dime groove for
upsetting.

Best results - upset cut blanks before
annealing. Surplus - 227,706 oz.
Annealed 240,000 oz., before upsetting,
this was reason for so much surplus.
Annealing and upsetting bent so many
when annealed before upsetting.

Aug 6 - 11-4-69

5 Centimeter ✓ 33 - 12-15-69L
" ✓ 7 - 12-16-69V
" ✓ 34 - 12-4-69V

334 fruit
total

✓ 25 - 11-14-69L
✓ 25 - 11-13-69V
✓ 55 - 11-4-69L
✓ 55 - 11-6-69L
✓ 3 - 11-4-69V
✓ 70 - 11-3-69V
✓ 38 - 11-5-69L
✓ 38 - 11-28-69

10 Centimeter Aug 2 - 11-28-69

202 fruit
total

✓ 8 - 11-28-69
✓ 8 - 11-3-69L
✓ 38 - 10-31-69V
✓ 76 - 10-30-69L
✓ 70 - 10-29-69L

25 Centimeter ✓ 40 - 11-12-69L

✓ 101 - 11-10-69L
✓ 105 - 12-22-69
✓ 35 - 12-23-69
22 - 1-7-70

304 fruit
total

one coil fruit special Catur Rice

Government Costa Rica

No. Pieces 10,000,000

Date order received 11-17-69

Mint where coined Denver

Denomination 10 Centimos

Date coinage started 10-23-69

Date coinage completed 12-3-69

Cost per M _____

Alloy 75% Copper - 25% Nickel
30.864 ± 2 Grains

Weight per coin _____

Weight tolerance _____

Fineness _____ Tol. _____

Diameter .707 Tol. _____

Thickness .050 Tol. _____

Reeded edge Yes

Plain edge No

Lettered edge No

Wastage allowed per M _____

Turn - standard or medal Standard

Year (dated) 1969

Mint mark No

Was sample coin submitted Yes

Was sample strike approved Yes

Date shipped _____

Remarks:

Obv. Die Average 105,263

Rev. Die Average 65,789

Was master die furnished _____

Was master die returned _____

Number melts made 192 ²⁰²

No, melts delivered to Coiner 192 ²⁰²

Ounces per melt 5800

No. ingots per melt One

Weight per ingot 400 lbs.

Size of ingot 60" X 12 1/8" X 1 3/4"

Assay passing tol. on ingot _____

Diameter of cut blank .696

Thickness of cut blank .035

Diameter of upset blank .686

Edge thickness upset blank .042 - .043

Pieces cut across strip 15

Pieces cut at one stroke 18

Annealing temperature 1450°

% rejects, automatic scales _____

% rejects if reviewed _____
per

% good coins ~~from~~ ingots 53,865

No. pieces per bag 10,000

Weight tol., M pieces _____

U. S. Dime Upsetting
U. S. Average dime collar used
U. S. Oversize dime punch used

Government Costa Rica

No. Pieces 4,000,000

Date order received _____

Was master die furnished No

Mint where coined Denver

Was master die returned No

Denomination 25 Centimos

Number melts made 304

Date coinage started 10-23-69

No. melts delivered to Coiner 304

Date coinage completed 1-21-70

Ounces per melt 5800

Cost per M _____

No. ingots per melt One

Alloy 75% Copper - 25% Nickel

Weight per ingot 400 lbs.

Weight per coin 53.24 - 2 Grains

Size of ingot 60" X 12 1/8" X 1 3/4"

Weight tolerance _____

Assay passing tol. on ingot _____

Fineness _____ Tol. _____

Diameter of cut blank .921

Diameter .907 Tol. ± .002

Thickness of cut blank .037

Thickness .055 Tol. ± .022

Diameter of upset blank .897

Reeded edge No - Lettered

Edge thickness upset blank .048

Plain edge No

Pieces cut across strip 9

Lettered edge Yes

Pieces cut at one stroke 12

Wastage allowed per M _____

Annealing temperature 1450

Turn - standard or medal Standard

% rejects, automatic scales _____

Year (dated) 1969

% rejects if reviewed _____

Mint mark No

% good coins from ingots 57%

Was sample coin submitted Yes

No. pieces per bag 4,000

Was sample strike approved Yes

Weight tol., M pieces _____

Date shipped _____

Remarks:

Obv. - Die Average 57.971

Rev. - Die Average 57.971

Lettered on edge B.C.C.R. - We lettered before stamping. Not too satisfactory. With proper adjustment on lettered segments this could be lettered after stamping and not show on coin edge and letters were plain with naked eye. Special dressing tool used for upsetting same for disc with lettering.

Costa Rica

10 Continuum total 192 Cals

10-29	70	7 in
10-30	76	"
10-31	38	"
11-3	8	"

5 Continuum

total 251 ^{with} Snapped 9

11-3	38	7 in
11-4	70	"
11-5	38	"
11-6	55	"
11-13	25	"
11-14	25	"

6 Costa Drops

3 Costa Drops

25 Continuum

total 141 Cals

11-10	101	7 in
11-12	40	

Cuts 7 minutes
 10 Continues .08
 Coster Price .38
 11-12-69 .76
 1.92 T
 Complete

Cuts 7 minutes
 Coster Price .55
 5 Continues .38
 11-12-69 .70
 2.01 T

Cuts 7 minutes
 Coster Price
 25 Continues
 11-11-69 1.01

Roll Costa Rica

25 centesimos -

.037 thick

Dia. blank - .921

wt = 53.24

140 Coils.

UNITED STATES GOVERNMENT

Memorandum

Notebook - Payroll
Acct

TO : M&R, Coining, Cash & Deposits, Assay and
Mechanical Divisions

DATE: September 22, 1969

FROM : Cost Accounting

SUBJECT: Job Numbers for Costa Rica 5, 10 and 25 Centimos Coins

<u>M&R Ingot</u>	<u>Dept.</u>	<u>Job Charge</u>
Costa Rica Ingots	7700	7771
<u>Coining Division</u>		
<u>Process Weighing</u>	8100	8171 5 Centimo
	8100	8172 10 Centimo
	8100	8173 25 Centimo

Rolling & Blanking

Rolling Includes - Rolling, Slab Annealing and Slittering of Ingots.

	<u>Dept.</u>	<u>Job Charge</u>
Rolling	8200	8271-R 5 Centimo
Blanking	8200	8271-B 5 Centimo
Rolling	8200	8272-R 10 Centimo
Blanking	8200	8272-B 10 Centimo
Rolling	8200	8273-R 25 Centimo
Blanking	8200	8273-B 25 Centimo

Annealing

8300	8371 5 Centimo
8300	8372 10 Centimo
8300	8373 25 Centimo

Upsetting

8500	8571 5 Centimo
8500	8572 10 Centimo
8500	8573 25 Centimo

Selecting

Blanks	8800	8871-2 5 Centimo
Coins	8800	8871-3 5 Centimo
Blanks	8800	8872-2 10 Centimo
Coin	8800	8872-3 10 Centimo
Blanks	8800	8873-2 25 Centimo
Coin	8800	8873-3 25 Centimo

Buy U.S. Savings Bonds Regularly on the Payroll Savings Plan

COSTA RICA
CENTIMOS

5- ~~CENTIMOS~~ 20.000.000 pes.

026

1026 Gauge,

251

.591 CUT BLANK

CUPRO NICKEL

+ or - 2 grain

.574 UPSET

98 upel

.591 Finish Coin Size

15.4324 grain

1 gram -

10- CENTIMOS 10.000.000 pes.

035

.035 Gauge

192 Coils

.709 CUT BLANK

CUPRO NICKEL

+ or - 1 1/2 grain

.696 UPSET

.709 Finish Coin Size

wt. 2 gram

30.8648 grain

25- CENTIMOS - 4.000.000 pes.
SINGLE STRIKE

~~.0394 Gauge~~

CUT BLANK .921

CUPRO NICKEL

141 upel

UPSET

.905 Finish Coin Size

+ or - 2 grain

.0512 Finished Coin

(B. C. C. R.)

wt. 3.45 gram

old ~~.037~~ Gauge -

~~.031 + P~~

53.24 grains

new .036 " "

app.

grain = gram

-0.0648

COSTA RICA
CENTIMOS

5 - ~~centimos~~ 20.000.000 pes.

.022 Gauge,

.591 CUT BLANK

CUPRO NICKEL

for - 1g

.574 UPSET.

.571 Finish Coin size

15.4324 grains

1 gram -

10 - CENTIMOS 10.000.000 pes.

X-Ray.

058.

✓

.035 Gauge

.704 CUT BLANK

CUPRO NICKEL

for - 1 1/2 g

.696 UPSET

.0365 kth

.709 Finish Coin size

wt. 2 grams

31 grs.

30.8648 grains

25 - CENTIMOS - 4.000.000 pes.
SINGLE STRIKE

~~.0394 Gauge~~

CUPRO NICKEL

921 CUT BLANK

UPSET

.905 Finish Coin size

for - 2 grams

.0512 Finished coin -

(B. C. C. R.)

Gauge -

.031 + P

wt. 3.45 grams

53.24 grains

new

037

25 - 29,780. Coins-per-kgot.

grain = grams

- 0.0648

Costa Rica Black size

904

25 -

.038

Check Diameter

Blank ~~weight~~ 54.35 grains -

53.24 grains total - 2 -

Costa Rica Blank





Notes on Costa Rican Currency

1000

1000

